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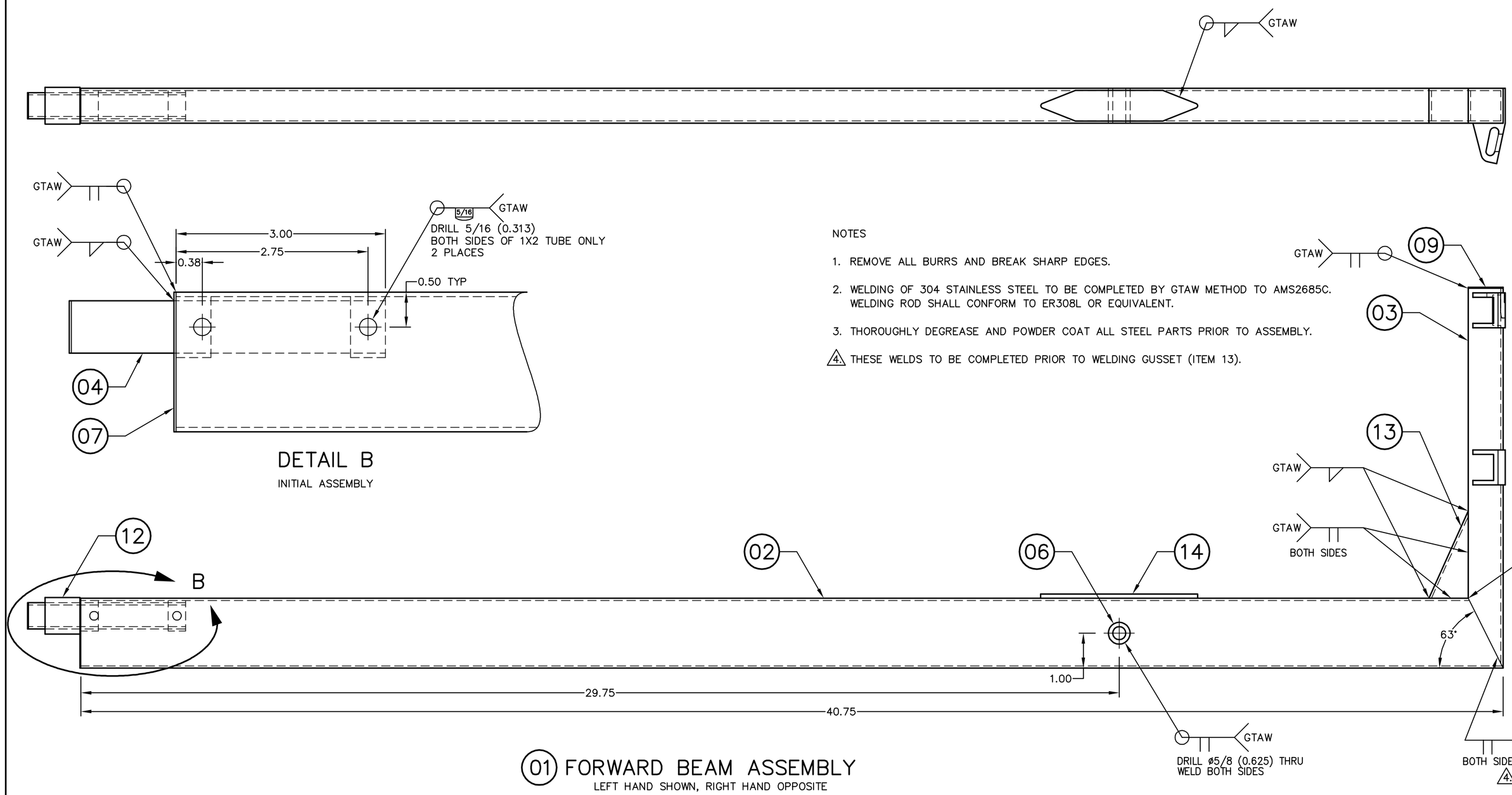
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; (11) CHANGED; (10) ADDED; (04) PARTS BROKEN OUT;	BJC	16/05/2014
	(07/08/09/14) MATERIAL CHANGED		



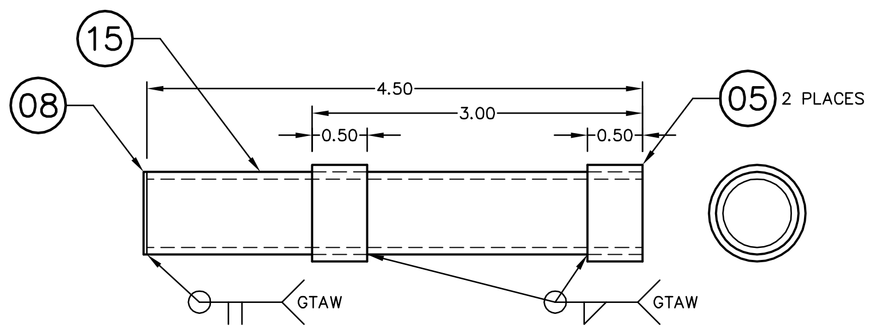
DETAIL B
INITIAL ASSEMBLY

NOTES

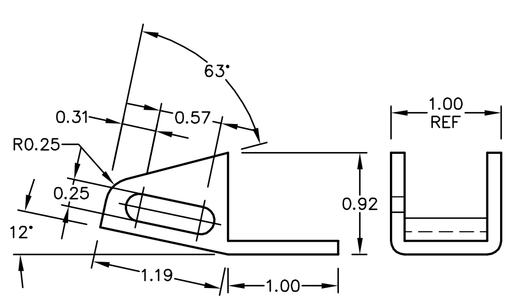
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE AND POWDER COAT ALL STEEL PARTS PRIOR TO ASSEMBLY.
4. THESE WELDS TO BE COMPLETED PRIOR TO WELDING GUSSET (ITEM 13).

01 FORWARD BEAM ASSEMBLY
LEFT HAND SHOWN, RIGHT HAND OPPOSITE

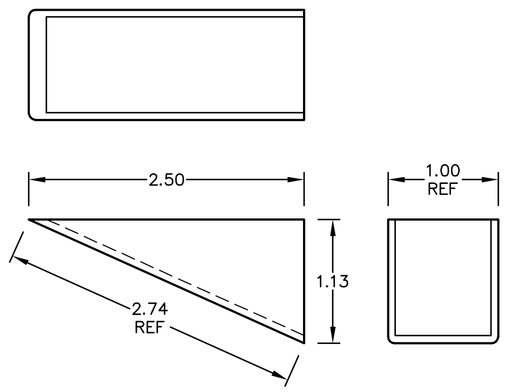
03 DOWN TUBE
LEFT HAND SHOWN, RIGHT HAND OPPOSITE



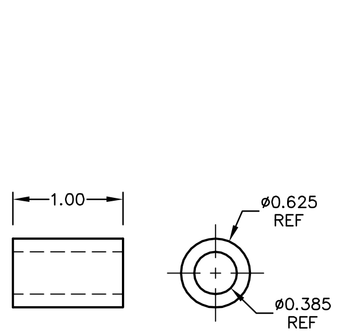
04 SUPPORT



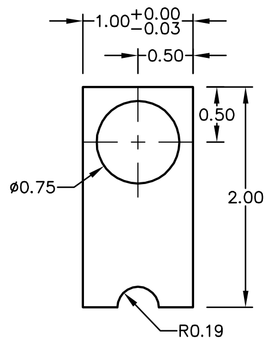
11 HOOK
LEFT HAND SHOWN, RIGHT HAND OPPOSITE



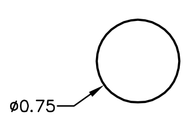
13 GUSSET



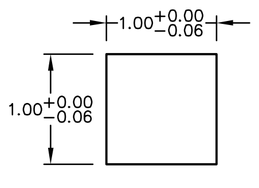
06 BUSHING



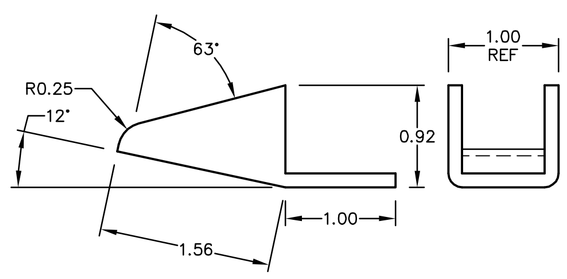
07 CAP



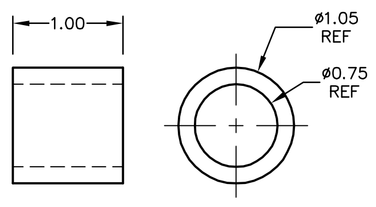
08 CAP



09 CAP



10 BRACKET



12 HOSE

QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS					
1			90630–15	15	TUBE	304 STAINLESS STEEL	ASTM A269	ø0.75 X 0.065 RND. TUBE
	1	1	69830–06	14	STRAP	304 STAINLESS STEEL	ASTM A240	0.12 SHEET
	1	1	90630–13	13	GUSSET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.065 TUBE
	1	1	90630–12	12	HOSE	RUBBER HEATER HOSE	COMMERCIAL	ø0.75 ID HOSE
	1		90630–11–02	11	HOOK (LH)	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.120 TUBE
		1	90630–11–01	11	HOOK (RH)	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.120 TUBE
	1	1	90630–10	10	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.120 TUBE
	1	1	90630–09	09	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1			90630–08	08	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
	1	1	90630–07	07	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
	1	1	90630–06	06	BUSHING	304 STAINLESS STEEL	ASTM A269	ø0.625 X 0.120 RND. TUBE
2			90630–05	05	RING	304 STAINLESS STEEL	ASTM A269	ø0.875 X 0.065 RND. TUBE
	1	1	90630–04	04	SUPPORT ASSEMBLY			
	1		90630–03–02	03	DOWN TUBE (LH)	304 STAINLESS STEEL	ASTM A554	1 X 0.065 SQR. TUBE
		1	90630–03–01	03	DOWN TUBE (RH)	304 STAINLESS STEEL	ASTM A554	1 X 0.065 SQR. TUBE
	1	1	90630–02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.065 TUBE
			90630–01–02	01	FORWARD LEFT BEAM ASSEMBLY			
			90630–01–01	01	FORWARD RIGHT BEAM ASSEMBLY			

APPROVALS		DATE
DRAWN:	JEFF CLARKE	31 AUG 2010
CHECKED:	E. BURGOIN	30 SEPT 2010

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES ±1/2°

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ROBINSON R44, R44 II
QUICK RELEASE CARGO BASKET
FORWARD BEAM ASSEMBLY

SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	90630	1